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CLAIMS

1. A reclosable bag comprising:

a receptacle having an interior volume at least partially filled with product and a mouth at the top of said interior volume;

5 a shroud having a generally U-shaped profile, said shroud defining a shrouded space and comprising a first surface on one side of said shroud that bounds said shrouded space and a second surface on the other side of said shroud that faces outward, wherein a first portion of said shroud is joined to said first wall and a second portion of said shroud is joined to said second wall, said shroud covering said mouth of said receptacle with at least a
10 portion of said shrouded space being disposed outside of said interior volume of said receptacle; and

a slider-zipper assembly disposed in said shrouded space and joined to third and fourth portions of said shroud on opposing sides of said shrouded space.

15 2. The reclosable bag as recited in claim 1, wherein said receptacle further comprises a first side gusset on one side of said reclosable bag interconnecting said first and second walls, and a second side gusset on an opposite side of said reclosable bag interconnecting said first and second walls, said first and second walls and said first and second side gussets partly
20 defining said interior volume.

3. The reclosable bag as recited in claim 1, wherein said first portion of said shroud is joined to a portion of an interior surface of said first wall, and said second portion of said shroud is joined to a portion of an interior surface of said second wall.

25 4. The reclosable bag as recited in claim 1, wherein said shroud comprises a folded film web.

5. The reclosable bag as recited in claim 1, wherein said slider-zipper assembly comprises:

5 a flexible zipper comprising first and second flanged zipper parts, said first flanged zipper part comprising a first profiled closure member and a first flange, and said second flanged zipper part comprising a second profiled closure member and a second flange, said first and second profiled closure members being mutually interlockable, said first flange having a portion joined to said third portion of said shroud, and said second flange having a portion joined to said fourth portion of said shroud; and

10 a slider mounted to said zipper and configured to close portions of said zipper as said slider is moved in a first direction along said zipper and to open portions of said zipper as said slider is moved in a second direction along said zipper opposite to said first direction.

15 6. The reclosable bag as recited in claim 5, wherein said first flange has a second portion joined to a fifth portion of said shroud, said third and fifth portions of said shroud being on the same side of said shrouded space.

7. The reclosable bag as recited in claim 6, wherein said first flange has a line of weakened tear resistance.

20 8. The reclosable bag as recited in claim 1, wherein said shroud has at least one line of weakened tear resistance extending in a lengthwise direction.

25 9. The reclosable bag as recited in claim 1, further comprising a pull bead joined to a fifth portion of said shroud, said pull bead extending in a lengthwise direction.

10. The reclosable bag as recited in claim 2, wherein a fifth portion of said shroud is joined to a portion of a panel of said first side gusset,

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and a sixth portion of said shroud is joined to a portion of a panel of said second side gusset.

11. A reclosable bag comprising:

5 a receptacle comprising first and second walls that partly define an interior volume, said receptacle having a mouth at the top of said interior volume and being closed at the bottom;

10 a shroud having a generally U-shaped profile, said shroud defining a shrouded space and comprising a first surface on one side of said shroud that bounds said shrouded space and a second surface on the other side of said shroud that faces outward, wherein a first portion of said shroud is joined to said first wall and a second portion of said shroud is joined to said second wall, said shroud covering said mouth of said receptacle with at least a portion of said shrouded space being disposed outside of said interior volume of said receptacle;

15 a flexible zipper disposed within said shrouded space and comprising first and second flanged zipper parts, said first flanged zipper part comprising a first profiled closure member and a first flange, and said second flanged zipper part comprising a second profiled closure member and a second flange, said first and second profiled closure members being mutually interlockable, said first flange having a portion joined to a third portion of said shroud, and said second flange having a portion joined to a fourth portion of said shroud, said third and fourth portions of said shroud being on opposite sides of said shrouded space, said first and second portions of said shroud being located intermediate said third and fourth portions; and

25 a slider mounted to said zipper and configured to close portions of said zipper as said slider is moved in a first direction along said zipper and to open portions of said zipper as said slider is moved in a second direction along said zipper opposite to said first direction.

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12. The reclosable bag as recited in claim 11, wherein said receptacle further comprises a first side gusset on one side of said reclosable bag interconnecting said first and second walls, and a second side gusset on an opposite side of said reclosable bag interconnecting said first and second walls, said first and second walls and said first and second side gussets partly defining said interior volume.

13. A method of manufacture comprising the following steps:

(a) mounting a slider to a zipper comprising interlocked first and second zipper strips;

(b) folding a length of a web along a fold line;

(c) joining a portion of a length of a first flange of said first zipper strip to a first portion of said length of said web;

(d) joining a portion of a length of a second flange of said second zipper strip to a second portion of said length of said web, said first and second portions of said length of said web being on opposite sides of said fold line;

(e) cutting said joined lengths of said web and said zipper along first and second lines generally perpendicular to said first edge to form an individual shrouded slider-zipper assembly that includes said slider;

(f) joining a third portion of said length of said web to a first portion of a pre-made bag that partly defines a mouth; and

(g) joining a fourth portion of said length of said web to a second portion of said pre-made bag that partly defines said mouth.

14. The method as recited in claim 13, wherein step (b) is performed prior to steps (c) and (d).

15. The method as recited in claim 13, wherein step (b) is performed subsequent to step (c) and prior to step (d).

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16. The method as recited in claim 13, further comprising the step of forming a line of weakened tear resistance in said length of said web, said line of weakened tear resistance being disposed in a lengthwise direction.

5 17. The method as recited in claim 13, further comprising the step of joining a pull bead to a fifth portion of said length of said web prior to said folding step.

18. The method as recited in claim 13, further comprising the step of inserting a portion of said individual shrouded slider-zipper assembly inside said mouth of said pre-made bag prior to performing steps (f) and (g).

10 19. The method as recited in claim 13, further comprising the following steps:

clamping said individual shrouded slider-zipper assembly during said cutting step;

opening said mouth of said pre-made bag; and

15 moving said clamped individual shrouded slider-zipper assembly from a location whereat said cutting step is performed to a position whereat a portion of said clamped individual shrouded slider-zipper assembly is disposed inside said open mouth.

20 20. The method as recited in claim 13, further comprising the step of tack sealing said length of said web to said pre-made bag prior to steps (f) and (g).

21. A reclosable bag comprising:

25 a receptacle comprising a first layer made of paper and a layer of thermoplastic material laminated to said first layer, said receptacle having a mouth and an interior volume;

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a shrouded slider-zipper assembly attached to said mouth of said receptacle, said shrouded slider-zipper assembly comprising first and second flanged zipper parts made of thermoplastic material, a slider mounted to said first and second zipper parts, and a folded web of thermoplastic film material joined to said layer of thermoplastic material of said receptacle, said first flanged zipper part comprising a first profiled closure member and a first flange, and said second flanged zipper part comprising a second profiled closure member and a second flange, said first and second profiled closure members being mutually interlockable, said first flange having a portion joined to one side of said folded web, and said second flange having a portion joined to the other side of said folded web; and

product contained inside said interior volume of said receptacle.

22. The reclosable bag as recited in claim 21, wherein said receptacle further comprises a second layer of paper laminated to said first layer of paper, said second layer of paper having printing thereon.

23. The reclosable bag as recited in claim 21, wherein said receptacle comprises first and second mutually opposing walls, a first side gusset on one side of said reclosable bag interconnecting said first and second walls, and a second side gusset on an opposite side of said reclosable bag interconnecting said first and second walls, said first and second walls and said first and second side gussets partly defining said interior volume.

24. The reclosable bag as recited in claim 23, wherein said one side of said web is joined to a first portion of said first wall, and said other side of said web is joined to a portion of said second wall, a portion of a first panel of said first side gusset, and a portion of a first panel of said second side gusset.

25. The reclosable bag as recited in claim 24, wherein a portion of a second panel of said first side gusset is joined to a second portion of said first wall, and a portion of a second panel of said second side gusset is joined to a third portion of said first wall.

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26. An automated system comprising:

means for mounting a slider to a zipper comprising interlocked first and second zipper strips;

means for folding a length of a web along a fold line;

5 means for joining a portion of a length of a first flange of the first zipper strip to a first portion of the length of the web;

10 means for joining a portion of a length of a second flange of the second zipper strip to a second portion of the length of the web, the first and second portions of the length of the web being on opposite sides of the fold line;

means for cutting the joined lengths of the web and the zipper along first and second lines generally perpendicular to the first edge to form an individual shrouded slider-zipper assembly that includes the slider;

15 means for joining a third portion of the length of the web to a first portion of a pre-made bag that partly defines a mouth; and

means for joining a fourth portion of the length of the web to a second portion of the pre-made bag that partly defines the mouth.

20 27. The system as recited in claim 26, further comprising a movable clamp that clamps an individual shrouded slider-zipper assembly during cutting, and suction means for opening the mouth of the pre-made bag, said movable clamp being programmed to move a clamped individual shrouded slider-zipper assembly from a location whereat cutting is performed to a position whereat a portion of the clamped individual shrouded slider-zipper assembly is disposed inside the open mouth of the pre-made bag.

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28. The system as recited in claim 26, further comprising means for tack sealing the length of web to the pre-made bag before they are joined together.